

Thursday, 10/07/2008 1:38:27 PM

Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	X-TUBE AS 350/355 HI AFT UNDER REVIEW
<b>Job Number</b> :	40413		
<b>Estimate Number</b> :	13225		
<b>P.O. Number</b> :		<b>Part Number</b> :	D350748241TRN
<b>This Issue</b> :	10/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D350-748-241 REV.D
<b>First Issue</b> :	1 /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40113	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	CROSSTUBES	<b>Due Date</b> :	17/07/2008
<b>Written By</b> :		<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b> :	JMD 08.7.10		
<b>Comment</b> :	Est Rev:A New Issue 08-03-06 DD verified by:ec Est Rev B Removed polish 08.04.02 EC verified by : DD Est Rev C Removed LPS-3 08.06.23 Ec verified by: DD		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6018125

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD X 2.000" ID

Batch: B 27472

Q.m 08.07.15 ①

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3- File transition lines smooth.

Q.m 08.07.15 ①

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Q.m 08.07.15 ①

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2- File transition lines smooth.

Q.m 08.07.15 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/07/2008 1:38:27 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 40413

Part Number: D350748241TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Scribe part # as per Dwg D350-748-241

AWM 08.07.15 (1)

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

AWM 08.07.15 (1)

6.0

QC8

SECOND CHECK



AWM 8-7-15



Comment: SECOND CHECK

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7263

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

C208/09/29 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

8/11/18 (1)

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8/11/18 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in kanban rack

Location:

Back hall

NP 8-11-19

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/20

Job Completion



CMF 08-11-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40413
<b>Description:</b> Crosstube Assembly (AS350/355 High Aft)		<b>Part Number:</b> D350-748-241
<b>Inspection Dwg:</b> D350-748-241 <b>Rev:</b> D		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.212	✓			
	2.234	+0.005/-0.000	2.238	✓			
	2.253	+0.005/-0.000	2.254	✓			
	2.272	+0.005/-0.000	2.276	✓			
	2.299	+0.005/-0.000	2.299	✓			
	0.063	+/-0.010	0.063	✓			
	4.26	+/-0.030	4.290	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
SIDE B	2.240	+0.005/-0.000	2.245	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.212	✓			
	2.234	+0.005/-0.000	2.238	✓			
	2.253	+0.005/-0.000	2.254	✓			
	2.272	+0.005/-0.000	2.276	✓			
	2.299	+0.005/-0.000	2.299	✓			
	0.063	+/-0.010	0.063	✓			
	4.26	+/-0.030	4.290	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
	122.70	+/-0.060	122.750	✓			

<b>Measured by:</b> a.m	<b>Audited by:</b> AHM	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08.02.15	<b>Date:</b> 8-7-15	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**

06.10.31

DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)		SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

**UNDER REVIEW**

07.02.16

OK CPJ.N 22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

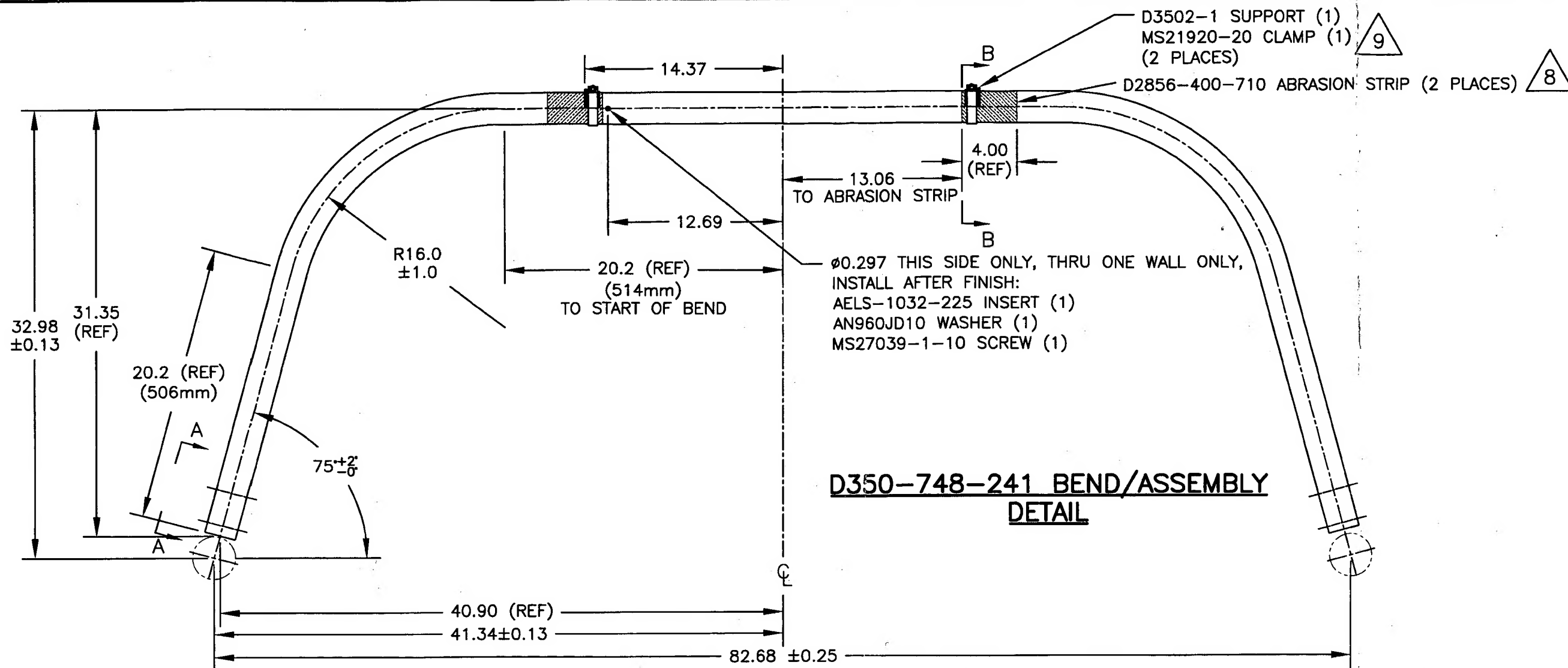
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

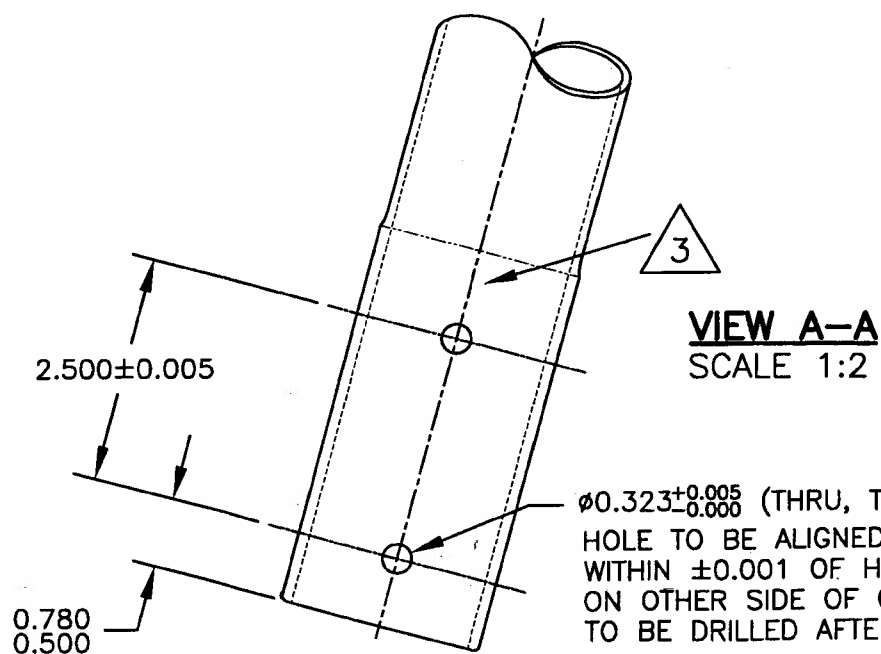
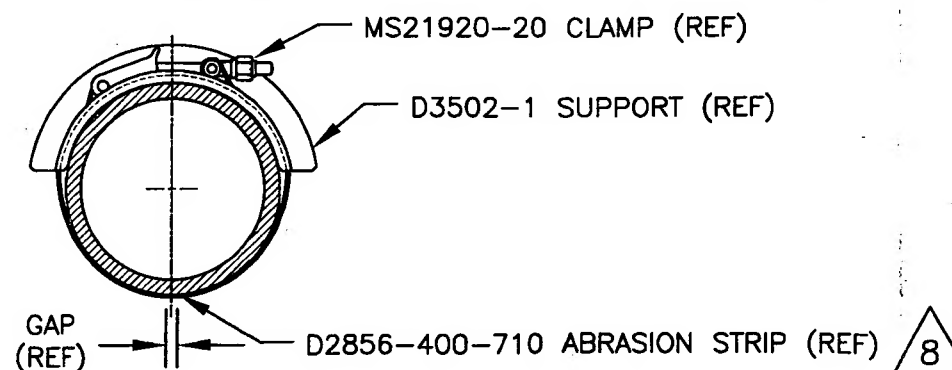
NOTE: Date & initial all entries





**D350-748-241 BEND/ASSEMBLY  
DETAIL**

**SECTION B-B  
SCALE 1:2**



**VIEW A-A  
SCALE 1:2**

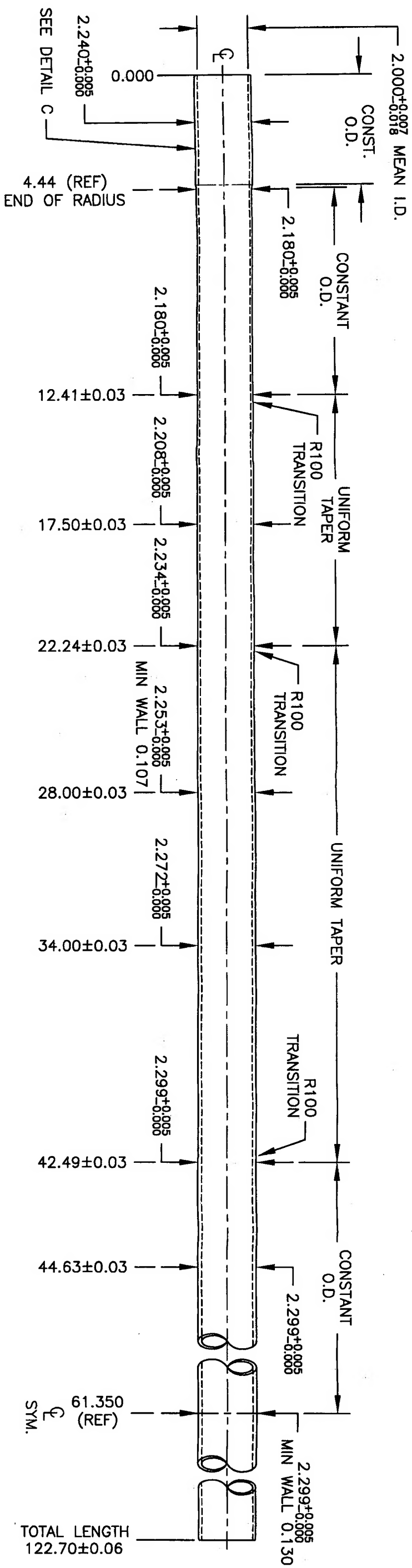
Ø0.323 ±0.005 (THRU, TYP)  
HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF,  
TO BE DRILLED AFTER BENDING

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 40413

**UNDER REVIEW**  
07.02/16  
CUFF FOR REDUCED  
Ø 0.7.11.22

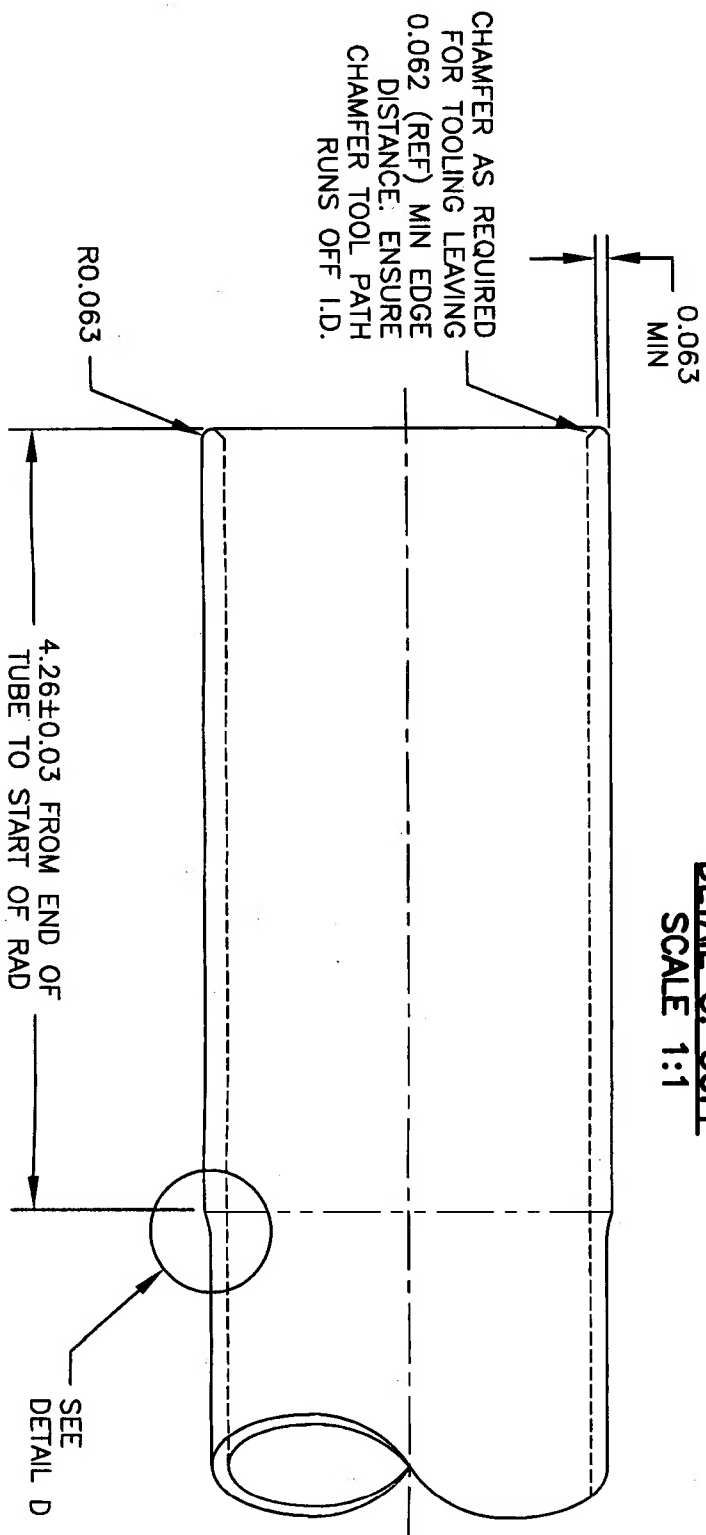
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	CHECKED H	APPROVED H		
	DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:

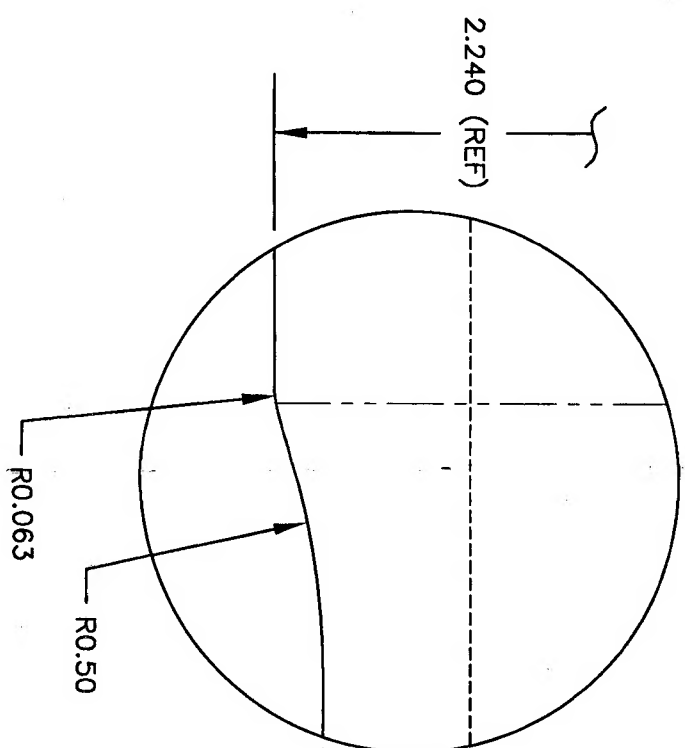


### D350-748-241 MACHINING DETAIL

**DETAIL C: CUFF**  
SCALE 1:1



**DETAIL D: CUFF TRANSITION**  
SCALE 9:1



**UNDER REVIEW**  
07.02/16  
07.02/16  
07.02/16

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WORK ORDER  
NO. 40415

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CHECKED	APPROVED		THUNDERBOLT, ONTARIO, CANADA
DATE		DRAWING NO.	REV. D
06.10.31		D350-748-241	SHEET 3 OF 3
		TITLE	SCALE
		CROSSTUBE (AS 350/355 HI AFT)	1:4





**VAC AERO**  
INTERNATIONAL INC.

# RELEASE NOTE

GST No.: R105468102

OAK 103192-4



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6I 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

11/14/2008

MM / DD / YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/14/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00007262/ 7409		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141 / -241	EA	11	11	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1D 100% HARDNESS TESTED AS PER ASTM E-18: 40-45 HRC GRIT BLASTED MATERIAL: 4130</p> <p>PO# PO00007262 4 PIECES D350-748-141: B40419, B40418, B40102, B40420 3 PIECES D350-748-241: B40110, B40413, B40414</p> <p>PO# PO00007409 4 PIECES D350-748-241: B42482, B42483, B42484, B42485</p> <p>NOTE: UNABLE TO FIND SERIAL NUMBERS ON PARTS</p> <p><i>Solve</i></p>					

**100% HARDNESS TESTED**

11 pcs.

41/42 HRC



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

*Solomon*  
Authorized Q.C. Inspector



HEAT  
TREATING



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS